



An Iron-Aluminum, Cored Wire
Made Exclusively for the
Twin Wire Arc Spray Process

EuTronic® Arc **535 Wire**



- Dense, well bonded coatings
- May be used as a rough, anti-skid coating
- Easily adjustable to achieve specific coating properties

EuTronic® Arc 535AS

EuTronic Arc 535 is an iron-aluminum, cored wire manufactured exclusively for the twin wire arc spray process. The coatings produced are suitable for two broad applications. First, EuTronic Arc 535 can be used as a dense, bond coating for subsequent top coatings, including galvanizing with zinc wire. Second, EuTronic Arc 535 can be used as a rough, anti-skid coating for a wide range of applications.

The specific coating properties desired can be achieved by adjusting spray parameters and primarily by adjusting the atomizing air pressure.

TECHNICAL DATA

Typical Values	
Hardness:	35 HRC
Deposit Efficiency:	80%
Bond Strength:	8000 psi
Density:	6.78 g/cc
Spray Rate:	10 lb/hr/100 amps
Wire Coverage:	Anti-Skid: 0.5 oz/ft ² /mil
Dense, Bond Coating:	0.8 oz/ft ² /mil

PROCEDURE FOR USE:

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated.

Note: It is best not to handle surfaces after cleaning.

The recommended method of surface preparation is to grit blast with 24 mesh aluminum oxide.

Please contact your Eutectic Surface Coatings Specialist for more information.

Spray Parameters:

Diameter:	*1.6 mm
Air Pressure:	*15 psi (anti-skid) *50 psi (dense, bond coating)
Voltage:	*27-30
Amperage:	*200-350
Standoff:	*4 in. (anti-skid) *5 in. (dense, bond coating)

**Parameters are typical and may vary depending on the equipment used. Contact your equipment manufacturer for optimum spray parameters.*

TYPICAL APPLICATIONS

As Non-Skid Coating:

- Ship deck
- Metal walkway
- Truck ramps
- Traction rolls
- Road construction plates

As Bond Coating:

- Machine element repair

To ensure a safe work environment observe normal welding practices, provide appropriate eye, hearing, skin and respiratory protection and pay attention to air flow patterns. For general spray practices, see AWS Publications AWS C2. 1-73, "Recommended Safe Practices for Thermal Spraying" and AWS T55-85, "Thermal Spraying, Practice, Theory and Application." Thermal spraying is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before starting spray operations. DO NOT operate your spraying equipment or use the spray material supplied, before you have thoroughly read the equipment instruction manual. Refer to the Eutectic web site for Material Safety Data Sheet (MSDS) information. . DISREGARDING THESE INSTRUCTIONS MAY BE HAZARDOUS TO YOUR HEALTH.



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